

**DART**

|                      |                        |  |                        |
|----------------------|------------------------|--|------------------------|
| DESIGN<br><i>MOX</i> | DRAWN BY<br><i>MOX</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br><i>KE</i> | APPROVED<br><i>MOX</i> | DRAWING NO.<br>D2500   | REV. F<br>SHEET 1 OF 2 |
| DATE<br>97:09:29     |                        | TITLE<br>EXTRUSION   | SCALE<br>NTS           |
| A                    | 96:03:19               | NEW ISSUE  |                        |
| B                    | 96:03:24               | CHANGE INTERNAL WEB  |                        |
| C                    | 96:04:26               | ADD D2500-3 WEB  |                        |
| D                    | 96:10:07               | ADD MATERIAL PROPERTIES                                      |                        |
| E                    | 96:10:24               | CHANGE MATERIAL TEMPER                                       |                        |
| F                    | 97:09:29               | CHANGE MAT. TO 6061-T6                                       |                        |
| F1                   | 01.04.17               | ADD NOTES 4 & 5 <i># UP</i>                                  |                        |

**RELEASED**  
97/10/06 DS

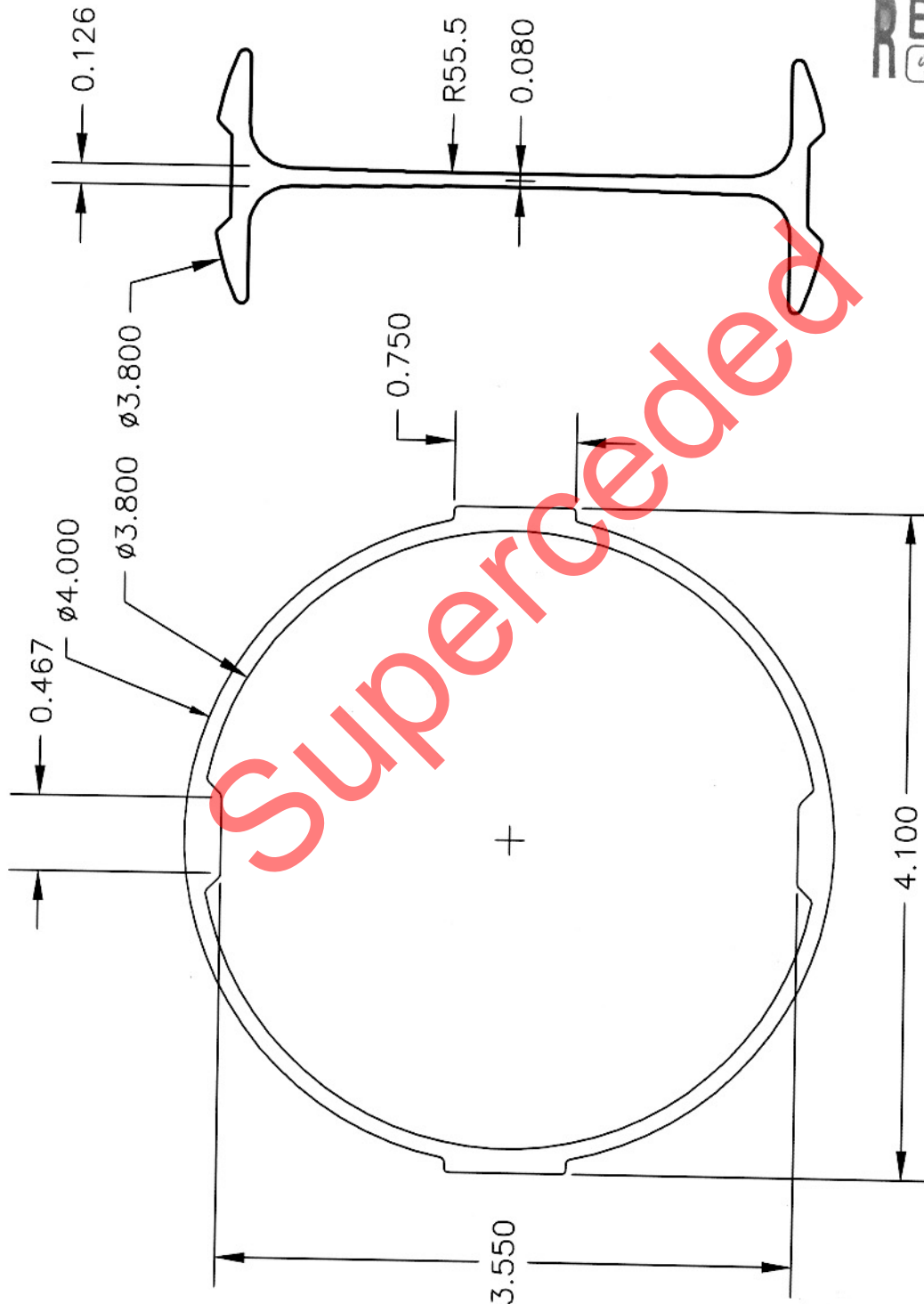
- MATERIAL: 6061-T6 (QQ-A-200/8)  
MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8 %  
  
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.
- BREAK ALL SHARP CORNERS 0.010 MAX
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)  
D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # 897105 → PREFERRED  
b) CARADON MIDWEST DIE # PAH-28030  
c) CARADON MTL DIE # MH-18868
- FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)  
D2500-3 EXTRUSION MANUFACTURED FROM CARADON INDALEX DIE # MS-18867

**DART**



|                      |                        |  |                        |
|----------------------|------------------------|--|------------------------|
| DESIGN<br><i>MBJ</i> | DRAWN BY<br><i>MBJ</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br><i>KE</i> | APPROVED<br><i>MBJ</i> | DRAWING NO.<br>D2500   | REV. F<br>SHEET 2 OF 2 |
| DATE<br>97:09:29     |                        | TITLE<br>EXTRUSION   | SCALE<br>1:1           |

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D2500-3

D2500-1